



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D2564

Job Sheet 184802



Part No: D2564

Job Qty: 30 ea

Part Name: Mounting Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B1 IPP: D 02.09.09 Re-format; Added FA276 Folio KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Machining		mmc 11/14/18
100	Bandsaw	30 pcs	11/23/18	11/23/18	0.00	1.25	Bandsaw1		11
110	CNC Vertical Machining	30 pcs	11/23/18	11/23/18	0.06	3.71	HAAS 1		11
130	QC	30 pcs	11/23/18	11/23/18	0.00	0.00	QC8		2018-11-05
140	Packaging	30 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3		SLL
150	QC21-SA	30 Ea	11/23/18	11/23/18	0.00	0.00	QC21		DAG

Part Op 100 - Cut D6207 Extrusion: 1.00" Long
Descriptions: 110 - 1- Mill as per Folio FA276 Rev: _____ & Dwg D2564 Rev: _____
140 - *** STOCK IN STEP CELL ***

21 NOV 07 2018
9-05

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6A1.000W.125	6061T6 Angle 1.00 X 1.00 X .125W	2.7480 ft (.0916 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6A1.000W.125	3	9	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Angle	1.000inches ± 0.030	1.030 0.970		
2	Mounting Angle	0.625inches ± 0.010	0.635 0.615		
3	Mounting Angle	0.257inches ± 0.010	0.267 0.247		
4	Mounting Angle	1.000inches ± 0.010	1.010 0.990		
5	Mounting Angle	1.000inches ± 0.010	1.010 0.990		
6	Mounting Angle	0.375inches ± 0.010	0.385 0.365		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		MRB (QSI042) Approval							
Description Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 11/05/18 Container No: S124417 Part: D2564 Job No: 184802 Serial No/Batch: S124417 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's		Completed By							
		Lead hand / Supervisor Approval Verification							
		QC / QA Coordinator Approval							
		Root Cause <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%; border-right: 1px solid black;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verificati ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verificati ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%; border-right: 1px solid black;"> Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 33%; border-right: 1px solid black;"> Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width: 33%;"> Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>			Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐
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OTHER : _____									